

Work Order ID 74477

Monday, October 03, 2011 9:45:16 AM

Page 1

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 11/10/03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
by 11/11/19 ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/11/20

10 0

B.A 11/11/20

10 0

B.A 11/11/20

10 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 74477

Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X Ø m-11/11/22

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:00

3200F

3:30

10X Ø m-11/11/22

M118434

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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H:\FORMS\Quality Assurance\approved QANCRWO RevE

Work Order ID 74477

Page 3

Monday, October 03, 2011 9:45:16 AM

Item ID: D2661-2

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Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BL 11-11-22

170

Identify as per dwg & Stock Location 3776 0.00

Packaging

Memo

0.00

Packaging

16XSP 11-11-23

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/11/23 AFMF 11-11-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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H:\FORMS\Quality Assurance\approved QAWCRWO RevE

Picklist Print

Monday, October 03, 2011 9:45:21 AM

Page 1

Work Order ID: 74477



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	10			

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

~~74680~~

~~11/10/26~~

→ 74650

10.0

LA 11/11/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD		Work Order: 74477
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.125	0.125	0.125	0.125		0.125
B	0.100	0.140		0.133	0.132	0.133	0.133		0.134
C	1.250	4.270		1.134	1.1343	1.1337	1.134		1.135
D	0.615	0.685		0.680	0.680	0.680	0.680		0.680
E	0.240	0.260		0.256	0.256	0.256	0.256		0.256
F	1.437	1.467		1.328	1.328	1.328	1.328		1.328
G	0.210	0.230		0.227	0.227	0.227	0.227		0.227
H	0.100	0.180		0.135	0.135	0.135	0.135		0.135
I	2.470	2.510		2.490	2.490	2.490	2.490		2.490
J	1.565	1.585		1.575	1.574	1.5744	1.574		1.5744
K	0.235	0.240		0.237	0.237	0.237	0.237		0.237
L	0.100	0.120		0.109	0.109	0.110	0.109		0.109
M	0.990	1.010		0.999	0.999	0.999	0.999		0.999
N	0.510	0.515		0.512	0.512	0.512	0.512		0.512
O	5.990	6.010		6.000	6.000	6.000	6.000		6.000
P	1.245	1.255		1.250	1.250	1.250	1.250		1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500		2.500
R	0.313	0.318		0.314	0.314	0.314	0.314		0.314
S	0.315	0.322		0.316	0.316	0.316	0.316		0.316
T	2.495	2.505		2.500	2.500	2.500	2.500		2.500
U	1.357	1.367		1.362	1.362	1.362	1.362		1.362
V	0.787	0.807		0.797	0.797	0.797	0.797		0.797
W	0.540	0.560		0.550	0.550	0.550	0.550		0.550
X	1.674	1.684		1.679	1.679	1.679	1.679		1.679
Y	0.257	0.262		0.260	0.260	0.260	0.260		0.260
Z	0.912	0.932		0.922	0.922	0.922	0.922		0.922
AA	0.490	0.510		0.500	0.500	0.500	0.500		0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188		0.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>B. A.</u>
Date: <u>11/11/20</u>

Audited by: <u>[Signature]</u>
Date: <u>11/11/22</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

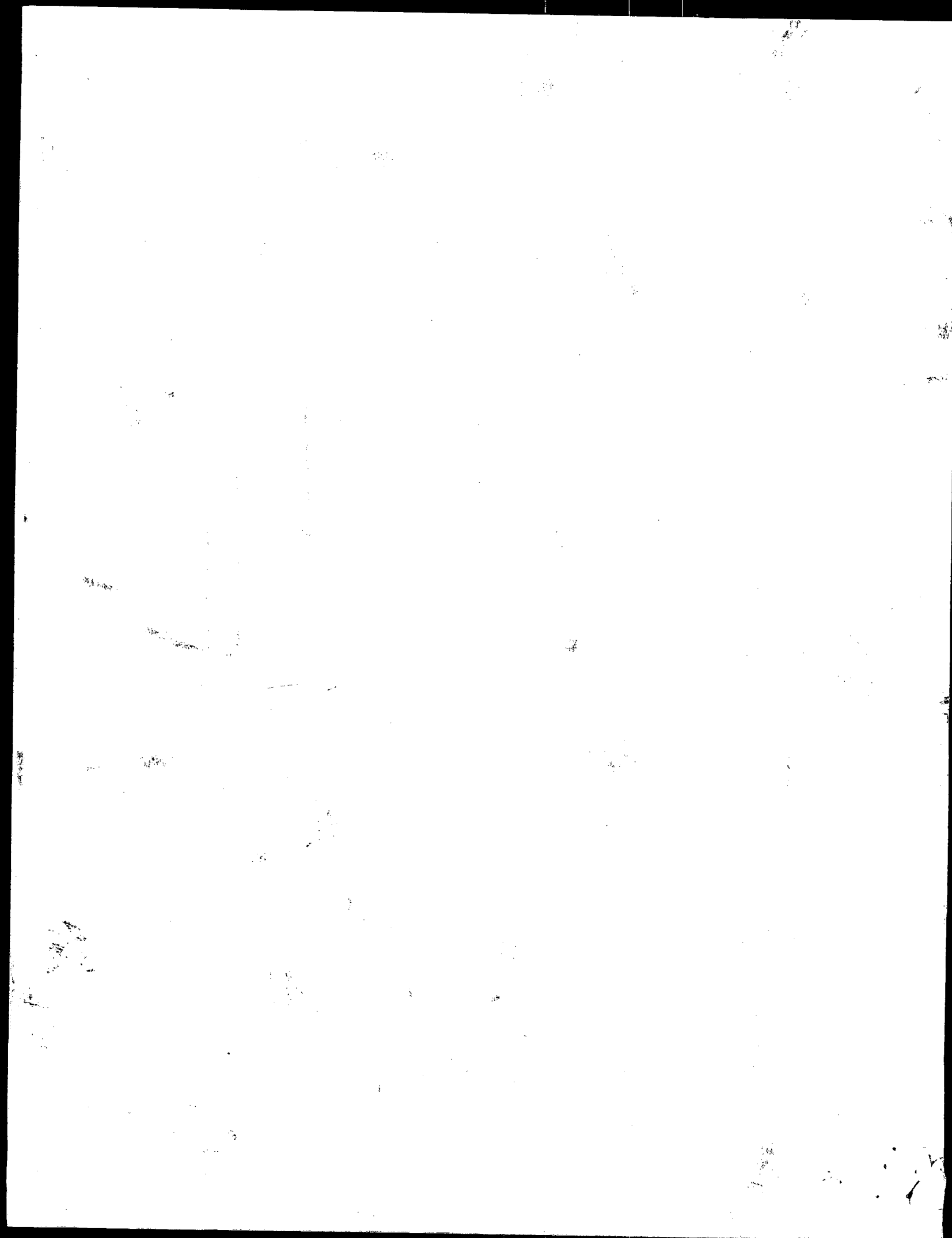
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				St	Date
				16	17	18	19		
A	0.100	0.140		0.125	0.125	0.125	0.125		0.125
B	0.100	0.140		0.133	0.133	0.133	0.134		0.133
C	1.125	1.145		1.136	1.1345	1.134	1.1346		1.134
D	0.615	0.685		0.680	0.680	0.680	0.680		0.680
E	0.240	0.260		0.256	0.256	0.256	0.256		0.256
F	1.313	1.343		1.328	1.328	1.328	1.328		1.328
G	0.210	0.230		0.227	0.227	0.227	0.227		0.227
H	0.100	0.180		0.135	0.137	0.135	0.135		0.135
I	2.470	2.510		2.490	2.490	2.490	2.490		2.490
J	1.565	1.585		1.5759	1.5743	1.574	1.5746		1.5743
K	0.235	0.240		0.237	0.237	0.237	0.237		0.237
L	0.100	0.120		0.111	0.109	0.109	0.109		0.110
M	0.990	1.010		0.999	0.999	0.999	0.999		0.999
N	0.510	0.515		0.512	0.512	0.512	0.512		0.512
O	5.990	6.010		6.000	6.000	6.000	6.000		6.000
P	1.245	1.255		1.250	1.250	1.250	1.250		1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500		2.500
R	0.313	0.318		0.314	0.314	0.314	0.314		0.314
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U	1.357	1.367		1.362	1.362	1.362	1.362		1.362
V	0.787	0.807		0.797	0.797	0.797	0.797		0.797
W	0.540	0.560		0.550	0.550	0.550	0.550		0.550
X	1.674	1.684		1.679	1.679	1.679	1.679		1.679
Y	0.257	0.262		0.260	0.260	0.260	0.260		0.260
Z	0.912	0.932		0.922	0.922	0.922	0.922		0.922
AA	0.490	0.510		0.500	0.500	0.500	0.500		0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188		0.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	M.A
Date:	11/11/20

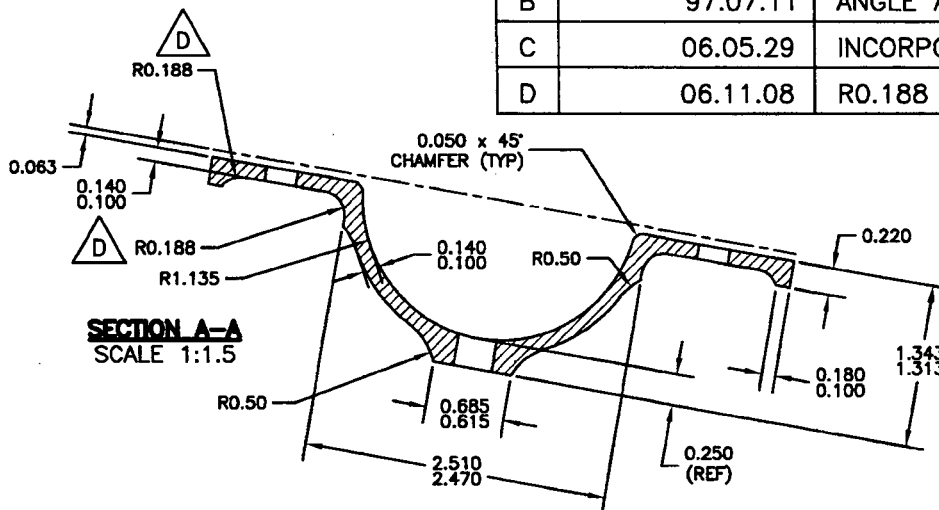
Audited by:	SA
Date:	11/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



RELEASED

0734012 #

RETURN TO

ENGINEERING

UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

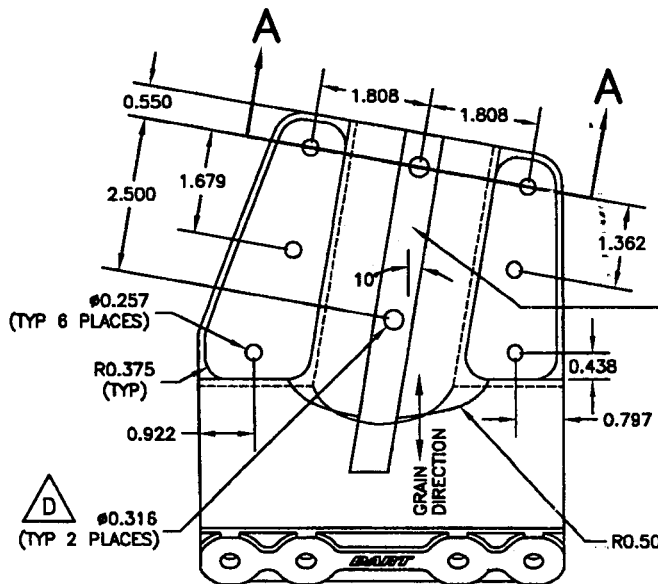
NO. 74477

M.C. 5

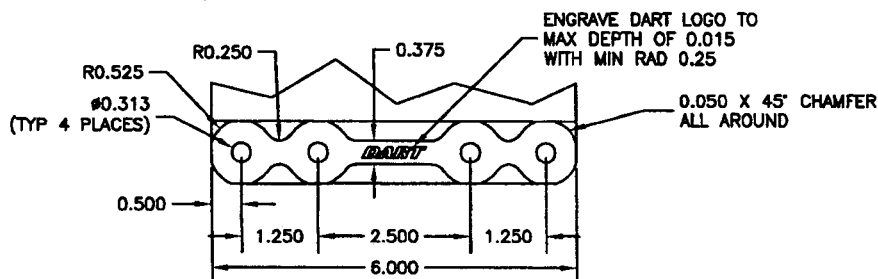
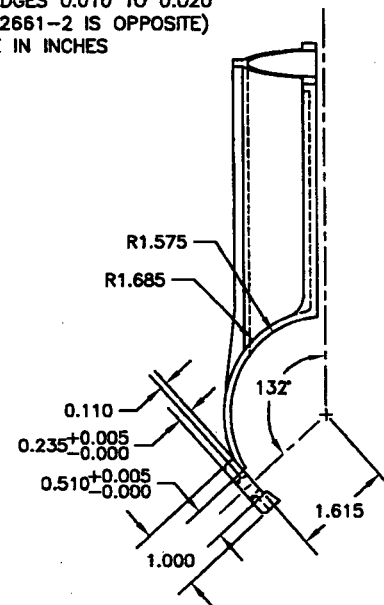
11/10/03

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE**

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries